

Work Order ID 75108

75108

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October-17-11 1:28:16 PM

Item ID: D3875-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector
Start Date: 17/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 04/11/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: M.L.J Date: 11/10/17 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3875	Rev A								

100 0.00
100
HandThermo Memo 0.00 x2 Wh.
Hand Finishing Thermoforming I-Cut Sheet to required Blank size 11/11/02

105 0.00
105
HandThermo Memo 0.00 x2 Wh.
Hand Finishing Thermoforming Dry Sheet as per QSI022 POLYCARBONATE 11/11/02
Temp: 240°F
Time IN: 2:30 PM
Time OUT: 11:30 PM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9435 Dwg Rev: <u>A</u> Folio Rev: <u>B</u>	0.00 0.00				<u>x2</u>			<u>DL</u> <u>11/11/03</u>
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect part for proper formation and texture	0.00 0.00				<u>x2</u>			<u>DL</u> <u>11/11/03</u>
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>x2</u>			<u>BB</u> <u>11/11/03</u>

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 17/10/2011 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x2

Dh

11/11/04

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

Complete FAI document

x 2

11/2

11/11/04

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control



11-11-84 (2)

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/11/11
 MF 11-11-07

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Picklist Print

October-17-11 1:28:20 PM

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Work Order ID: 75108

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Parent Item: D3875-1

D3875-1

Parent Item Name: Floor Protector

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased			No	100	sf	1,848.384	9.84	19.68			

MI FXS 118-90318-08

Lexan Sheet

**

Location

therm

Loc Qty

1848.384621

1848.38462

Loc Code

113127

19.68 sq ft

OK
11/11/03

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DART AEROSPACE LTD		Work Order:	75108
Description: Floor Protector		Part Number:	D3875-1
Inspection Dwg: D3875 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	<i>DL</i>	Date:	11/11/03
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.075"	✓		CAL TH-DT	
0.080	Min	0.085"	✓		CAL TH-DT	
45.2	+/-0.100	45.3 "	✓		TAPE DLOI	
21.8	+/-0.100	21.875"	✓		TAPE DLOI	
1.4	+/-0.100	1.413 "	✓		VERN DL-02	

Measured by:	<i>DL</i>	Date:	11/11/04
Audited by:	<i>JBB</i>	Date:	11/11/04
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

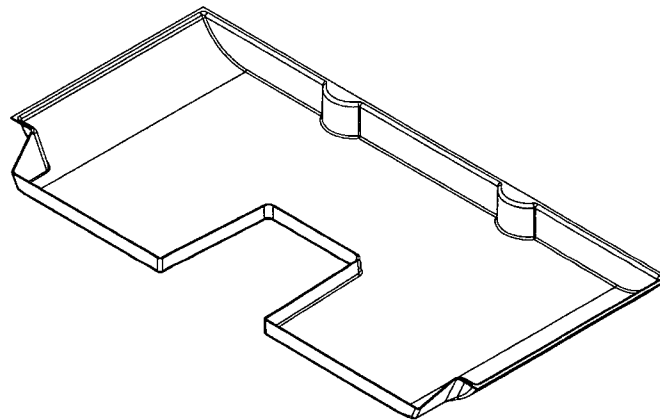
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D3875-1 FLOOR PROTECTOR (206B)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75108 M.L.J
11/10/17

RELEASED
29/05/05

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AK		
DRAWN	AK		
CHECKED	13		
MFG. APPR.	13		
APPROVED	AK		
DE APPR.	AK		
DATE	09.01.29		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3875	SHEET 1 OF 2
TITLE	FLOOR PROTECTOR (206B)	SCALE NTS
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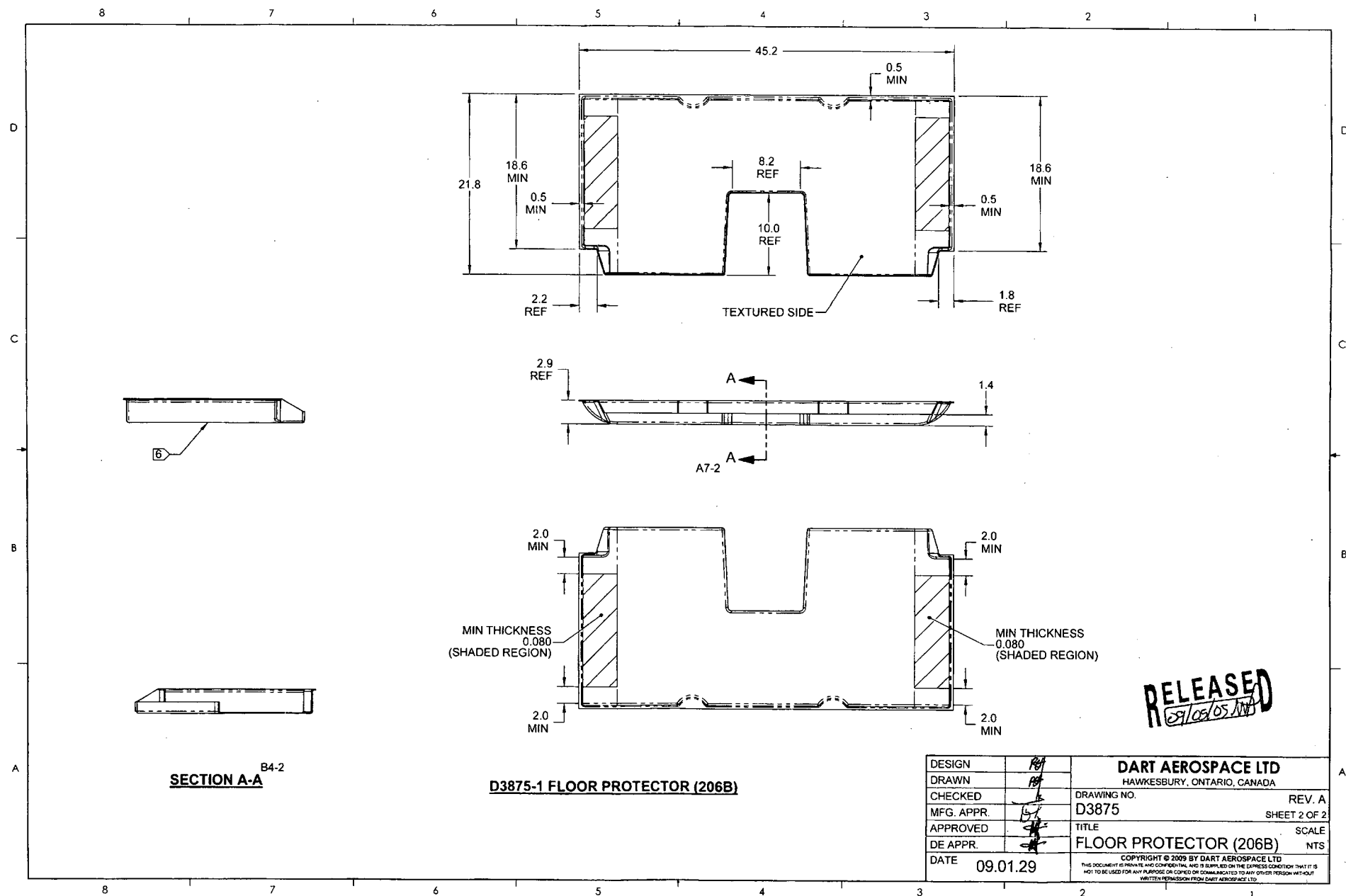
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